




Work Order ID 62749

Thursday, October 07, 2010 3:09:03 PM


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Item ID:	D2842-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Assembly, 206 Float					
Start Date:	10/7/2010	Start Qty:	4.00	Cust Item ID:		
Required Date:	10/15/2010	Req'd Qty:	4.00	Customer:		
Reference:						


Approvals:	Process Plan:		Date:	10-10-07	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2842	Rev B

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8271 as per Dwg D2842 3-Deburr and bevel ends for welding								

110	QC5- Inspect part completeness to step on W/O	0.00							
	QC6								
QC	Memo	0.00							
Quality Control									

120	Weld per dwg A/R Aluminum rod Batch: 1108436	0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld one end cap and (2) lugs using Jig DT followed by DT as per Dwg D2842 2-Grind end cap weld flush								

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries




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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				4	0	BE	10/11/09
140  QC Quality Control	QC9 Inspect part completeness to step on W/O Memo	0.00 0.00				4	0		PTO →
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4	0		10-11-09

Dart Aerospace Ltd

W/O: 62749		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		Perm. Change						
10/10/09	#110 #115	Change step to inspection level QCL					S 10/14/09	
		perm change	MA	10.11.16		10.11.11		
10.11.11	180	QC 9 change to QC 10 (AFT cap groove weld- not a critical weld)						
		perm change	MA	10.11.16		10.11.11	10.11.11	

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Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	<i>HL</i>	<i>10/11/09</i>		<i>4</i>	<i>0</i>		
170  Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <i>A108436</i> Large Fab Memo 1-Remove alodine prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.	0.00 0.00		<i>PC 10-11-10</i>		<i>4</i>	<i>0</i>		
180  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds <i>QC 10</i> Memo	0.00 0.00				<i>4</i>	<i>0</i>	<i>BE 10/11/11</i>	

See
p70
previous
page.

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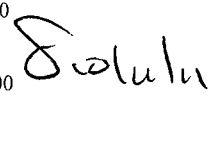

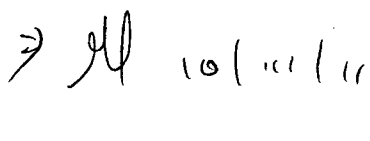



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Required Date:	10/15/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
191  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo ***Touch up step with alodine per qsi 005 prior to powder coat*** M 115291	0.00 0.00							
200  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 8:10 OVEN TEMPERATURE: 320° FINISH TIME: 8:40	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Required Date: 10/15/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # - Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

QC3- Inspect Part Finish

0.00

=> M 10/11/15

X4

φ

QC

Memo

0.00

Quality Control

220

HandFinishing

0.00

=> M 10/11/15

X4

φ

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: 1115740

230

QC3- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

PO ->

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		Perm. Change						
10/10/11	#735	Change step 6 QLG inspection test N/A					10/10/11	

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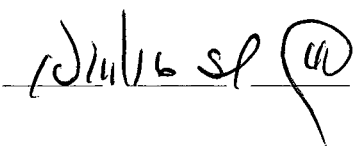

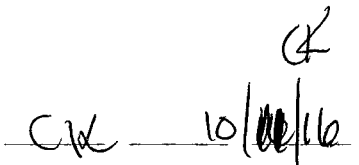
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
250  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							 10-11-16

W/O:		WORK ORDER CHANGES					
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Page 1

**Start Date:** 10/7/2010**Required Date:** 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM□□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960C10L  washer	<u>NAS1149C0332</u> R	Purchased	No			100	Each	29.0000	3	12			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST245			29						
					107534		29						
D2622-120C  Step Extrusion		Manufactured	No			120	Each	156.4200	1	4			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			156.42						
					55214		3.42						
					<u>58544</u>		25						
					61208		128						
D2734  Step End Plate		Manufactured	No			120	Each	65.0000	2	8			
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				WA			65						
					60216		5						
					61209		60						

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Picklist Print

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Work Order ID: 62749

Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

D3459-3 Manufactured No

120 Each

30.0000

2

8



Float Step Mounting Plate

Location

Loc Qty

Loc Code

WA

30

61214

12

62396

18

D3459-1 Manufactured No

220 Each

26.0000

2

8



Float Step Mounting Plate

Location

Loc Qty

Loc Code

WA

26

61213

26

MS27039C1-07 Purchased No

220 Each

67.0000

3

12



screw

Location

Loc Qty

Loc Code

ST293

67

111424

3

115460

64

NAS1329C3KB130 Purchased No

220 Each

76.0000

3

12



insert

Location

Loc Qty

Loc Code

ST276

76

111981

30

115719

46

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float



Start Date: 10/7/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

NAS1515H3L

Purchased

No

220

Each

380.0000

3

12



10/11/15

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

340

111819

94

113362

246

812

W/O:		WORK ORDER CHANGES					
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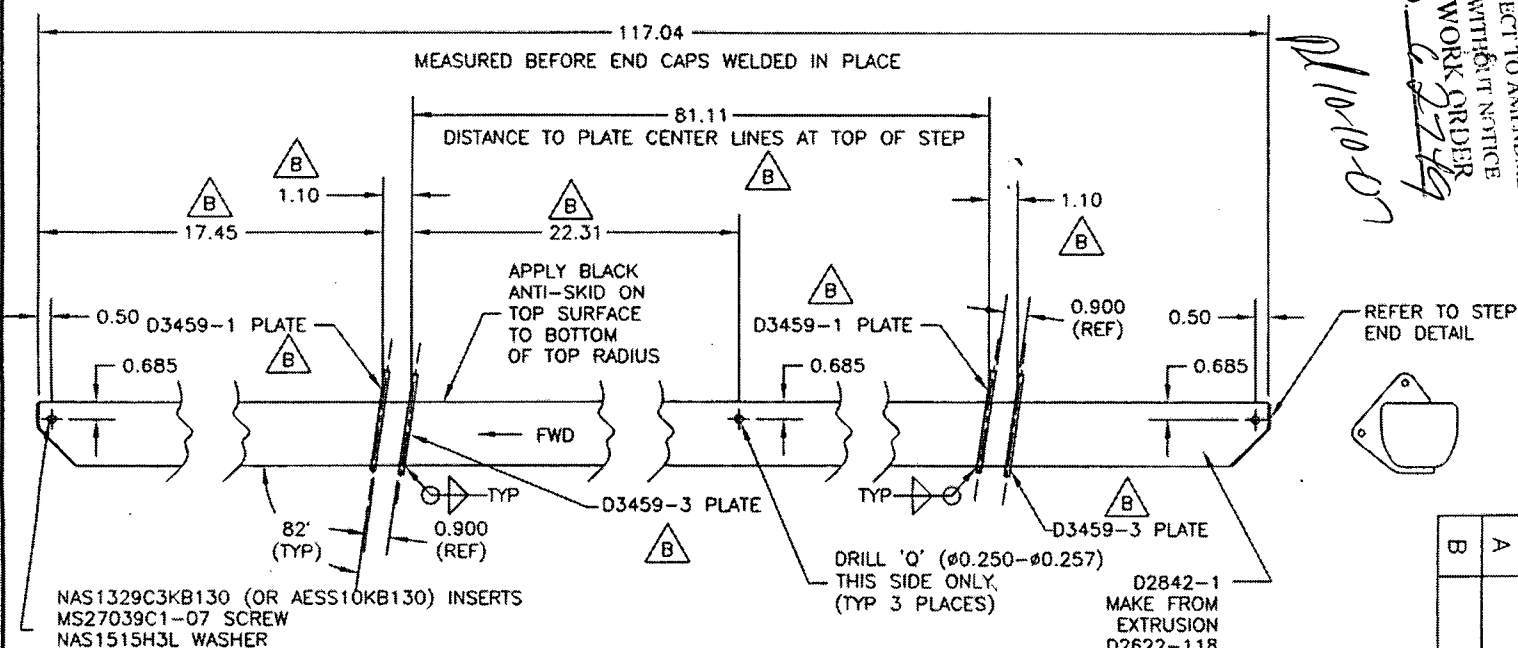
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DART

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 6-2249



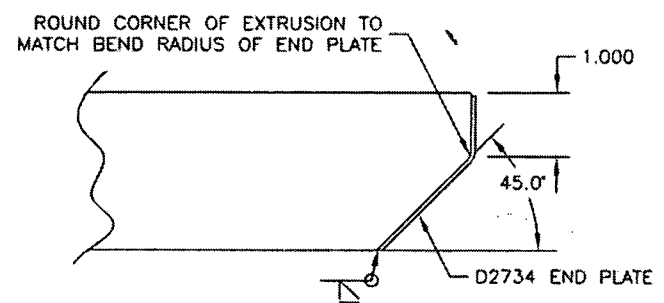
NAS1329C3KB130 (OR AESS10KB130) INSERTS
 MS27039C1-07 SCREW
 NAS1515H3L WASHER
 AN960C10L WASHER
 (TYP 3 PLACES)

D2842-041' LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

NOTE: ALL WELDS SHALL
 BE 100% VISUALLY
 INSPECTED BY A QUALIFIED
 INSPECTOR PER DART
 QSI 004

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL
 NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
 05-11-14

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DESIGN	KE	DRAWN BY	PH	DART Aerospace USA, Inc.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	REV. B
			206L/407 FLOAT STEP ASSEMBLY	SHEET 1 OF 1
			NEW ISSUE	SCALE
			RE-DESIGN, ADD D3459-1/-3	NTS

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